

Page 1

Friday, September 16, 2016 2:50:48 PM

Item ID: D350-689-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Provisions

Stop *NS2*

Start Date: 9/23/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/5/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 16/09/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

DAS 6

SEP 30 2016

DAS
21
9-89

16-10-02

100 Document Control
100 DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D350-689 bluefile & type labels per PPP D350-689-013 CHG 005

DAS
28
9-80

OCT 04 2016

101	Pick Kit	0.00
-----	----------	------

101

Packaging

Memo

0.00

Packaging

DAS
6
9-89

DA
27
9.8

OCT 03 201

110	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

110

OC

Memo

0.01

Quality Control

OCT 04 2018
 DIS
 28
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 151261

Friday, September 16, 2016 2:50:48 PM

151261

Page 2

Item ID: D350-689-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Provisions

Start Date: 9/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-013 Location: FG027								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.02							
Quality Control									

IX **DAS 28** **DAS 27** **OCT 04 2016**
9-89 9-89

DAS 21 **OCT 04 2016**
9-89

DAS 21 **OCT 04 2016**
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Picklist Print

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Page 1
15

Work Order ID: 151261

151261

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 9/23/2016

Required Date: 10/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev D 06.02.07 Re-format ec
 IPP rev E 06.02.28 Fixed typo ec
 IPP rev.F 07.01.02 per dsi 9311 ec IPP Rev:G
 10.06.07 remove qty 1 D3033-1 DD verf:EC IPP REV:H 11.11.17
 PER IIN REVB DD VERF:EC IPP REV:I 11.11.24 AS PER
 ECN11-674 DD VERF:EC IPP REV:J 12.11.20 AS PER DSI9588
 REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4575-3 *D4575-3* Doubler		Manufactured	No			110	Each	2.0000	1	1		OCT 03 2016	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST259				2					
					145611			2					
D3025-1 *D3025-1* Beam		Manufactured	No			110	Each	1.0000	1	1		OCT 03 2016	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST258				1					
					128214			1					
D4575-1 *D4575-1* Beam		Manufactured	No			110	Each	13.0000	1	1		OCT 03 2016	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST259				13					
					146063			6					
					147703			7					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐ _____					

Picklist Print

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Page 2

Work Order ID: 151261

151261

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 9/23/2016

Required Date: 10/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3027-1

Manufactured No

110

Each

12.0000

1

1

D3027-1

Clip

DAS
28
9-89

Location

Loc Qty

Loc Code

ST015

12

147726

12

110

Each

5.0000

1

1

D3027-3

Manufactured No

D3027-3

Clip

DAS
28
9-89

Location

Loc Qty

Loc Code

ST015

5

128215

5

110

Each

6.0000

1

1

D3027-5

Manufactured No

D3027-5

Clip

DAS
28
9-89

Location

Loc Qty

Loc Code

ST015

6

128216

6

110

Each

40.0000

4

4

D3027-7

Manufactured No

D3027-7

Clip

DAS
28
9-89

Location

Loc Qty

Loc Code

ST015

40

145824

39

147054

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Friday, September 16, 2016 2:50:48 PM

Page 3

Work Order ID: 151261

151261

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 9/23/2016

Required Date: 10/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3032-1

Manufactured No

110

Each

2.0000

1

1

OCT 03 2016

D3032-1

Spacer

**

Location

Loc Qty

Loc Code

ST259

2

113083

2

D3033-1

Manufactured No

110

Each

0.0000

2

2

OCT 03 2016

D3033-1

Seat Track

**

D3234-1

Manufactured No

110

Each

6.0000

1

1

OCT 03 2016

D3234-1

Doubler

**

Location

Loc Qty

Loc Code

ST258

6

128218

6

D3234-5

Manufactured No

110

Each

10.0000

2

2

OCT 03 2016

D3234-5

Spacer

**

Location

Loc Qty

Loc Code

ST026

10

150647

10

MS21059L3

Purchased No

110

Each

50.0000

12

12

OCT 03 2016

MS21059L3

Nut Plate

**

Location

Loc Qty

Loc Code

ST301

50

M135603

50

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID: 151261

151261

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 9/23/2016

Required Date: 10/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS24693-S273

Purchased

No

110

Each

481.0000

2

2

MS24693-S273

Screw

**

OCT 03 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

10

117291

10

ST286

471

100151

389

M129682

82

MS27039-1-10

Purchased

No

110

Each

252.0000

6

6

MS27039-1-10

SCREW

**

OCT 03 2016

DA
6
9-89

Location

Loc Qty

Loc Code

GA

12

m129541

12

ST280

240

m135603

240

DAS
28
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																					

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Work Order ID: 151261

151261

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 9/23/2016

Required Date: 10/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

1,764.000

6

6

DAS

NAS1149D0332J

Washer

**

OCT 03 2016

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

204

m134848

204

GA

300

m134848

300

ST260a

1200

m135566

600

m135672

600

ST264

54

m135536

54

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 151261

151261

Page 1

Friday, September 16, 2016 2:50:48 PM

Item ID: D350-689-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Provisions

Start Date: 9/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: 10/16/16Date: 10/16/16

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DAS
6

SEP 30 2016

100

Document Control

9-89

0.00

DAS
21
9-89

OCT 03 2016

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D350-689 bluefile & type labels per PPP D350-689-013 CHG 005

101

Pick Kit

0.00

101

Packaging

Memo

0.00

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.01

Quality Control

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
1		1				D3018-1	SEAT CUSHION
1		1				D3019-1	BACK CUSHION
	1					D3025-1	BEAM
	1					D3027-1	CLIP
	1					D3027-3	CLIP
	1					D3027-5	CLIP
	4		4			D3027-7	CLIP
				4		D3028-1	STUD
				2		D3029-1	SPRING
				2		D3030-1	LOCK
	1					D3032-1	SPACER
	2					D3033-1	SEAT TRACK
	1					D3234-1	DOUBLER
	2					D3234-5	SPACER
					2	D3808-041	SEAT RAIL ASSEMBLY
					4	D3809-1	SLIDING BLOCK
			1			D3811-041	SEAT TRACK ASSEMBLY
	1		1			D4575-1	BEAM
	1		1			D4575-3	DOUBLER
				1	1	D5162-041	SEAT STRUCTURE ASSEMBLY
			9			MS21042L3	NUT (OR MS21042-3)
	12					MS21059L3	NUTPLATE
	2					MS24693-S273	SCREW
			9			MS24694-S50	SCREW
	6					MS27039-1-10	SCREW
	6					NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)